Quality Control

May-21-13 3:29:59 PM Item ID: D3955-041 Accept *N900040100* Setup Start **Revision ID:** Item Name: Doubler Assembly **Start Date:** 5/21/13 Start Qty: 8.00 ***8*** **Cust Item ID:** Required Date: 6/04/13 Req'd Qty: 8.00 **Customer:** Reference: Run Process Plan: MLJ Date: 13-05-22 Tooling: Approvals: Date: Stop Date:_____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID Description **Run Hours** Number Stamp Code Qty Qty **Draw Nbr Revision Nbr** D3955 Α 100 0.00 *100* 8 Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3955-1 Dwg Rev: A 6061,063 Prog Rev: A 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* QC 0.00 Memo.

											DQA:	Date:	
NCR: Y	es /	No				WORK ORDER NON-C	100	NFORM	AANCE / UPDATE		,		
											QA Closed:	Date	
Work Orde	oŕ.					DISPOSITION			AGAI	NST DE	PARTMENT	PROCESS	•
Part N						Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Crossi Machining Small noforming Finis Large Fab Compo	hing	Pro	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	i	nitial	Action		Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
						F/	AUL	T CATE	GORY				
Landi	<u> </u>					General	_	1			1	_	7_
	Cr Cr	ending entre No acks ushed/(t Concer Crimped	ntric to (O/S	Bend BOM/Route Broken/Damaged Burrs		1	re on Incomplete ions Incomplete/Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi	t _	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	Cı	uffs eat Trea				Contamination Countersink		Mainte Mislabe	led		Part Moved Positioned V		, ,
	$\boldsymbol{\vdash}$	spectior pples in	Strip in Bend	Tube		Cut Too Short Drill Holes	-	Misread Offset	•	<u></u>	Power Loss/	Surge	Other

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

101919

May-21-13 3:29:59 PM

Item ID:

D3955-041

Accept

N900040100

Setup Start

Revision ID: Item Name:

Doubler Assembly

5/21/13 **Start Date:** Required Date: 6/04/13 Start Qty: 8.00 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling: SPC (Y/N):		ate:		R	kun Sta Sto	"	R1* R2*
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect part	s - second check	0.00				A			-
120			27				A			
QC	Mem	0	0.00 13 1 14				—9—		•	·
Quality Control			1701,							

130	
130	
Small Fab	
Small Fab	

0.00 Memo 1- C'sink holes as per dwg

2- Deburr if necessary

140 *140*

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

0.00

NCR: Y	res /	No				WORK ORDER NON-C	O	NFOR	MANCE / UP	DATE			
						· · · · · · · · · · · · · · · · · · ·					QA Closed:	Date	
Work Orde	er:					DISPOSITION	,		🗖	AGAINST DE	PARTMENT,)
Part N						Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	ı	nitial	Act	ion	Sign &		
Cause	נ	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUL	T CATE	GORY				
Landi	Cer Cra Cru Cu He Ins Rip	nding ntre No acks ushed/C ffs at Trea pection oples in rque W	Strip in Bend aves in E	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset Out of 0	ion Incomplete Lions Incomplete/U enance eled d Calibration	Inclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Tu	rning Se	equence		1	Finish		Out of 9	Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

May-21-13 3:29:59 PM

Required Date: 6/04/13

Item ID: D3955-041 Accept

N900040100

Setup Start

Revision ID: Item Name:

Start Date:

Doubler Assembly

5/21/13

Start Qty: 8.00 Req'd Qty: 8.00 *8*

Cust Item ID:

101919

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling			ate:		R	tun Stai Sto	"INKT"
	QC:	Date:	SPC (Y	/N):	D	ate:	·			" *NR2*
Sequence ID/ Work Center ID	Operation Description	1	Set U Run	Jp/ Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
150	Chemical Conve	rsion Coat per QSI005 4.1	0.00					$\widehat{}$	1	P p C 10
150 HandFinish	Mer	: no	0.00	k				4	HE	7/36-18
Hand Finishing										
				•						
160	QC3- Inspect Par	rt _i Finish	0.00	A Á.			•			
160		4		27				9		
QC	Men	no	0.00	12 4 10						•
Quality Control				136 B					¥ +	
		1								
		Į.								_

Pick Kit

Memo

170 Packaging

Packaging

170

0.00

0.00

÷										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON	-COI	NFOR	MANCE / UP	DATE	0.4.61		
										QA Closed:	Date:	**
Work Orde	or.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap Use-as-is		1	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update			Large Fab	Composite	, Recystor	Supplier	J Other
Root				Descr	iption of work order update		Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data quip/Tooling												
Operator												
Material		1										
Setup												
Other												
Process												
Supplier												
raining				-								
Jnapproved		<u> </u>					· -					
						FAUL	T CATE	GORY	·			
Landir	ng Gear				General	_	1			1		1
	Bending			-	Bend	<u> </u>	Grain		_	Ovalized	<u> </u>	Pressure/Forced
		ot Conce	ntric to (^{O/S} -	BOM/Route	\vdash	Hardwa		_	Over/Under		Temperature/Cure
	Cracks			-	Broken/Damaged	\vdash	4 `	on incomplete		Part Incorred	 	Weld
	Crushed	/Crimped		-	Burrs	<u> </u>	4	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			 	Contamination	\vdash	Mainte		<u> </u>	Part Moved	Maria	
	Heat Tre			 	Countersink	-	Mislabe		<u> </u>	Positioned V		Journal
	Inspection		fube	 	Cut Too Short	\vdash	Misread	I	L_	Power Loss/	Surge	Other
	Ripples in			 	Drill Holes	-	Offset					
		Vaves in E		^ <u> </u>	Drawing	<u> </u>	4	Calibration				
	Turning 9	Sequence	!	1	Finish		Out of S	Sequence				

Outside Dimensions

Wave/Twist in Tube

Packaging

May-21-13 3:29:59 PM Item ID: D3955-041 Accept *N900040100* Setup Start *N **Revision ID:** Item Name: Doubler Assembly **Start Date:** 5/21/13 Start Qty: 8.00 **Cust Item ID:** Required Date: 6/04/13 Req'd Qty: 8.00 **Customer:** Reference: Run Process Plan: _____ Date: ____ Tooling: Approvals: Date: QC: Date: **SPC (Y/N):** Date: Sequence ID/ Operation Set Up/ Tool # Plan Tool ID Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 180 0.00 *180* Small Fab 0.00 Memo Small Fab 1- Assemble nut plate as per dwg 190 QC5- Inspect part completeness to step on W/O *190* QC Memo Quality Control Identify as per dwg & Stock Location: 87074 200 *200* Packaging 0.00 Memo

											DQA:	Date:	
NCR:	⁄es	/ No				WORK ORDER NON-	100	NFORM	MANCE / UP	DATE			
											QA Closed	: Date:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N	No.					Rework Scrap Use-as-is Work Order Update		t Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
	•				_					· · · · · · · · · · · · · · · · · · ·	4 		
Root					I	ption of work order update	ł	Initial		tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	Ш								}				}
Equip/Tooling	Ш				1								
Operator													
Material			:										
Setup													
Other	П												
Process													
Supplier													
Training													
Unapproved													
		٠				F	AUL	T CATE	GORY				
Landi	ng G	Gear	-			General		_			_		_
[•		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
: <i>j</i>	П	Cuffs				Contamination		Mainte	nance		Part Moved		_
V		Heat Trea	t			Countersink		Mislabe	led		Positioned \	N rong	
		Inspection	n Strip in	Tube		Cut Too Short		Misread	I		Power Loss,	/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Quality Control

May-21-13 3:29:59 PM Item ID: D3955-041 Accept *N900040100* Setup Start **Revision ID:** Item Name: Doubler Assembly **Start Date:** 5/21/13 Start Qty: 8.00 **Cust Item ID:** Required Date: 6/04/13 Req'd Qty: 8.00 **Customer:** Reference: Start Run Process Plan: **Approvals:** Date: **Tooling:** Date: Stop Date:_____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 210 QC21- Final Inspection - Work Order Release 0.00 *210*

0.00

Memo

13-06-20 N 13-06-20

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-	COI	NFORI	MANCE / UPI	DATE	QA Closed:	Date:	
					T		T	· · · · · · · · · · · · · · · · · · ·		,		
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap		1	Skid-tube Machining	Crosstube Small Fab	⊣ '	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	lo				Use-as-is Work Order Update	_	Thern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data					•					1		
Equip/Tooling			}									
Operator											·	
Material												
Setup												
Other				'								
Process						1						
Supplier						-						
Training												
Unapproved						<u>.</u>						
					F.	AUL	T CATE	GORY				
Landi	ng Gear			_	General	_	7			7	_	Ī
	Bending				Bend	\vdash	Grain			Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to	O/S	BOM/Route	\vdash	Hardwa			Over/Under		Temperature/Cure
	Cracks				Broken/Damaged		1 `	ion Incomplete		Part Incorred		Weld
	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	1	Mainte	enance		Part Moved		

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Picklist Print

May-21-13 3:30:03 PM

Work Order ID: 101919

Parent Item:

D3955-041

Parent Item Name: Doubler Assembly

101919 *D3955-041*

Required Date: 6/04/13

Page 1

Start Qty: 8.00

Start Date: 5/21/13

Required Qty: 8.00

IPP RevA: New issi	ue DD verified b	y:EC										
Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location			Qty on e Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
	Purchased	No			100	sf	282.4125	0.3553	2.992			
SS 063*	1							**	3.0			JMB-6-1
	i.		Location		<u>I</u>	oc Oty	Loc Code					
	į.		MAT021		1 2	82.4125				_		
	i				<u> </u>			_		-		
	i .							V)×421	_	_	
	Purchased	No		120 131	180		43,0000	1	,	01		
31 3*	i							**		#SL	3/06	/18
	1		Location		I	oc Otv	Loc Code			,		
			ST319		1	_						
						3 40		_	9	-		
	Purchased	No			180	Each	2,215.000	2	16	11		. /
7M3-3*	:							**		/S1-	3 /0G	/18
	i .		Location		L	oc Qty	Loc Code			,	/ /	
	1		GA			44						
				121114		44		_		_		
	i i		ST335			2171		_		_		
	1			124231.		2171		-	_/8	_		
	Replacement Item ID	Replacement Item ID Purch Purchased Purchased Purchased Purchased	Purchased No Purchased No Purchased No Purchased No Purchased No	Replacement Item ID Purch Item Location Purchased No SS 063* Purchased No Purchased No Purchased No Purchased No Purchased No Location ST319 Purchased No Cocation ST319	Replacement Mfg/ Purch Item Location Location Purchased No SS 06.3* Location MAT021 123135 124003 125431 Purchased No ST319 Tocation ST319 Tocation ST319 Tocation ST319 Tocation ST319 Tocation GA Tocation Calculation Calculation	Replacement Mfg/ Purch Route Location Route Seq II	Purchased No Location Loc Oty	Replacement Mfg/ Purch Item Location Location Location Route Location Req ID Measure Hand	Replacement Mfg/ Item Item Location Location Route Unit of Route Qty on Qty per Kit	Replacement Mfg/ Item Primary Last Seq ID Weasure Hand Qty per Kit Total Qty	Replacement Mfg/ tem D lem Cocation Coc	Replacement Mfg/ Bin Primary Last Location Seq ID Unit of Qty on Qty per Kit Total Qty Issued Issued SS 063*

												DQA:	D	ate:		
NCR: Y	⁄es	/ No			-	WORK ORDER NON-C	:OI	NFORI	MANCE / UP	DATE						
											QA (Closed:	D	ate:		_
Work Orde	ع ر .					DISPOSITION				AGAINST D	EPAR1	MENT	/PROCESS			
Work Orac	- '				- ' -	Rework			Skid-tube	Crosstube			Water Je	t∏	Engineering	
Part N	No.					Scrap			Machining	Small Fab	7	Pro	d. Eng. Coor	\vdash	Quality	
	-			·. · · · · · · · · · · · · · · · · · ·		Use-as-is			noforming	Finishing	T R	ec/Sto	re/Packaging	g	Other	
NCR N	No.					Work Order Update			Large Fab	Composite]		Supplie	$r \square$		
																_
Root						ption of work order update		Initial		tion	Sig	gn &				
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription		ate	Verificati	on	QC Inspector	_
Doc/Data	Ц															
Equip/Tooling																
Operator	Щ															
Material	Ш	i														
Setup	Щ										-					
Other	Ш															
Process	Ш															
Supplier	Ш]											
Training	Н		İ	<u> </u>	ļ	·					l					
Unapproved			<u> </u>		<u> </u>		<u> </u>	TCATE	CORY	<u></u>			<u> </u>	1		-
							AUL	T CATE	GURY							-
Landi	_	i ear Bending				General Bend		Grain		. [Toval	bosi			Pressure/Forced	
		Centre No	at Cancar	atric to		BOM/Route		Hardwa	ro	-	⊣		tolerance	-	Temperature/Cure	
	⊢	Cracks	or concer	itric to	^{0/3}	Broken/Damaged	<u> </u>	1	on Incomplete	F	┥	Incorre		\vdash	Weld	
		Crushed/0	Crimped			Burrs	┢	4	ions Incomplete/	Linclear —	→	Lost/M		\vdash	Wrong Stock Pulled	
	${f H}$	Cuffs	camped		<u> </u>	Contamination	H	Mainte	•	-		Moved	-		1	
	-	Heat Trea	ıt			Countersink	\vdash	Mislabe		<u> </u>	⊣	ioned \				
	-	Inspection		Tube	<u> </u>	Cut Too Short		Misread		.	_	er Loss/			Other	
	$oldsymbol{oldsymbol{ o}}$	Ripples in				Drill Holes		Offset		L	_	·	•	ш		
	Н	Torque M		vtrucio	<u>,</u>	Drawing		Out of	Calibration							

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	101919
Description: Doubler	Part Number:	D3955-1
Inspection Dwg: D3955 Rev: A		Page 1 of 1

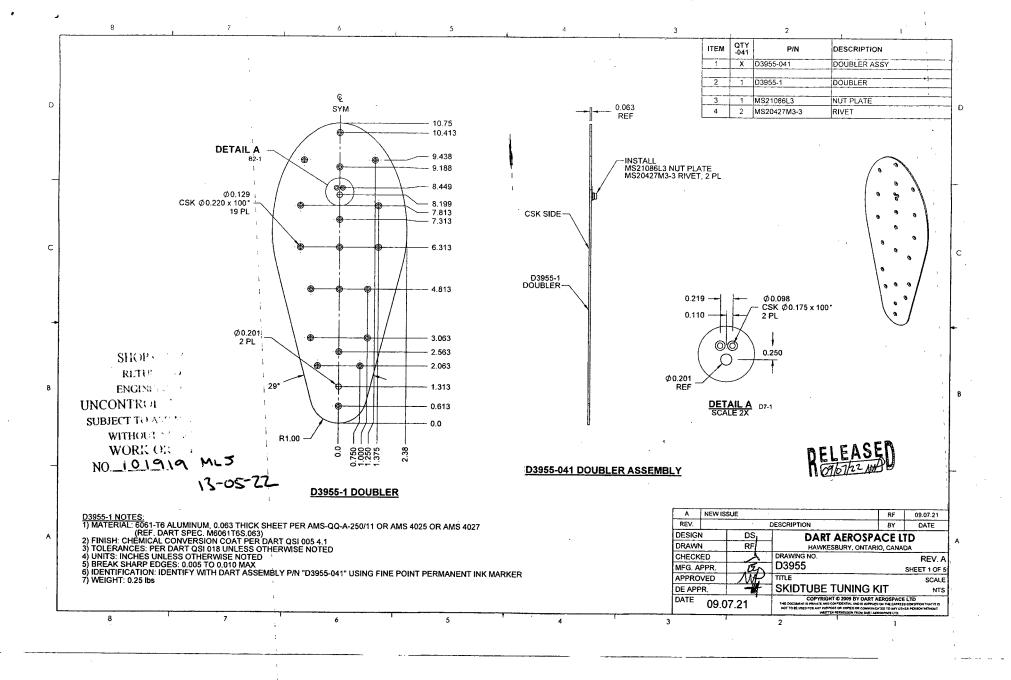
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

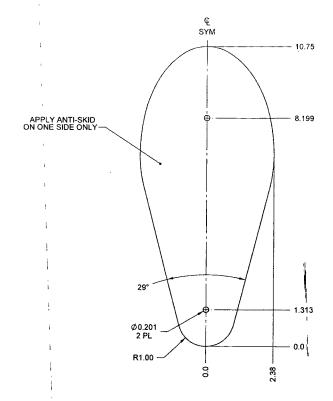
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0,132	_		U	Throi
Ø0.201	+0.005/-0.001	0.203" -			- U	
0.750	+/-0.010	0.748"	_		V	
1.000	+/-0.010	1.000	_		٧	
1.250	+/-0.010	b.249°	_		V	
1.375	+/-0.010	1.374	-		V	
2.38	+/-0.030	2 390"	·		V	
0.613	+/-0.010	66091	_		V	
1.313	+/-0.010	1.315"	_		٧	
2.063	+/-0.010	2.066	-		V	
2.563	+/-0.010	2.564"	_		U	
3.063	+/-0.010	3.063	-		V	
4.813	+/-0.010	4.813"	-		V_	
6.313	+/-0.010	6.310	_		V	
7.313	+/-0.010	7.311,	_		V	`
7.813	+/-0.010	7.807	-		V	
8.199	+/-0.010	8,200	-		V	Todayor
8.449	+/-0.010	જ્ઞ. પંજા	-		V	
9.188	+/-0.010	9.190	-		ν	
9.438	+/-0.010	9, 439"	-		V	
10.413	+/-0.010	10.426	-		ν	
10.75	+/-0.030	10.75"			V	
0.063	+/-0.010	0.061	A		U	

Measured by:	Jm	Audited by:	27	Prototype Approval:	N/A
Date:	13-6-14	Date:	13614	Date:	N/A
Day Date	Chama				

Rev	Date	Change		Revisedby	Aphroved
Α	09.07.29	New Issue	P/O D3955-041	KJ 🕏	THE STATE OF THE S
				1 71	



D



D3955-3 COVER PLATE

NOTES:

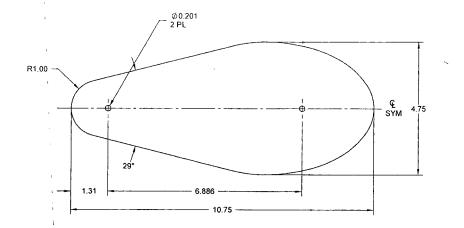
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.060 (16 GA) THICK (REF. DART SPEC. M304S16GA)
2) FINISH: BLACK ANTI-SKID PAINT PER DART GSI 005 4.4
3) TOLERANCES: PER DART GSI 018 UNIESS OTHERWISE NOTED
4) UNITS: INCHES UNIESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-3" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.64 lbs

8

DESIGN	DS,	DART AEROSPACE	LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CAN	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	(F)	D3955	SHEET 2 OF 5
APPROVED	MM	TITLE	SCALE
DE APPR.	-#	SKIDTUBE TUNING KIT	NTS
DATE 09.0	7.21	COPYRIGHT © 2009 BY DART AEROSPA THE DOCUMENT OF PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXO NOT TO BE USED FOR ANY AURICUS OR COMED OR COMMUNICATES TO ANY	MESS COMPONENT THAT IT IS OTHER PERSON WITHOUT

--- 0.060 REF

101919



D3955-X PLATE

General Table				
P/N	T (in)	T (GA)	WEIGHT (lbs)	
D3955-5	0.060	16	0.64	
D3955-7	0.120	11	1.28	

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304S'T'GA)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

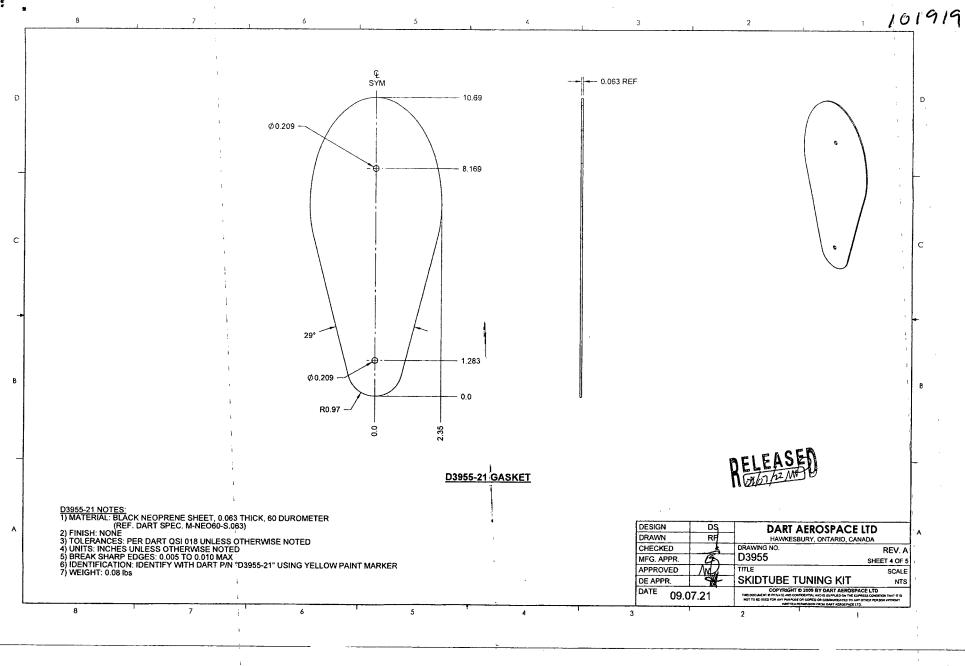
4) UNITS: INCHES UNLESS OTHERWISE NOTED

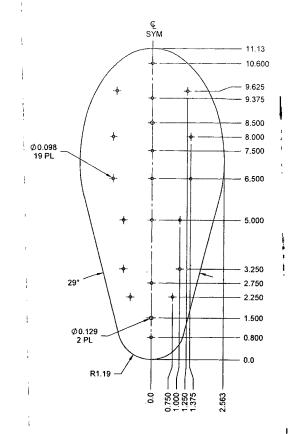
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: SEE TABLE

DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DS, DRAWN RF DRAWING NO. CHECKED REV. A D3955 MFG. APPR. SHEET 3 OF 5 TITLE APPROVED SCALE DE APPR. SKIDTUBE TUNING KIT NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD DATE 09.07.21





- 0.040 REF

DESIGN DS, DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN RF DRAWING NO. CHECKED REV. A D3955 MFG. APPR. SHEET 5 OF 5 APPROVED TITLE SCALE SKIDTUBE TUNING KIT DE APPR. NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD DATE 09.07.21

D3955-23 TEMPLATE

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM, 0.040 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-23" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.16 lbs